

FIG.1A

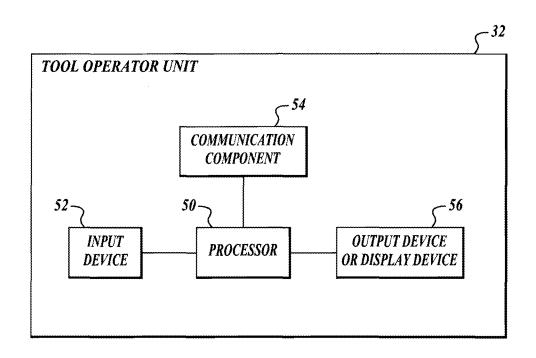


FIG.1B

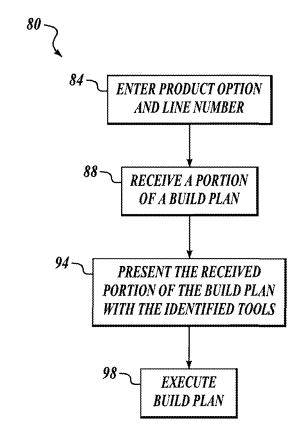


FIG.2

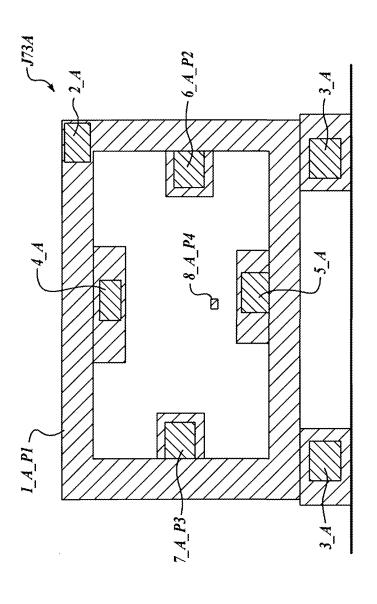


FIG. 3

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DRILL HOLES X, Y, V, Z WITH DRILL FEATURE 5_A INSTALL STIFFENER LOCATOR (6_A_P2) INSTALL STIFFENER LOCATOR (7_A_P3) ATTACH PANEL TO MAIN ASSY (1_A_P1) PIN (8 A P4) RETRIEVE TOOL J73A 102 COP 10 106 ~ OP 30 108 ~ OP 40 110 ~ OP 50 **PLAN**

FIG.4

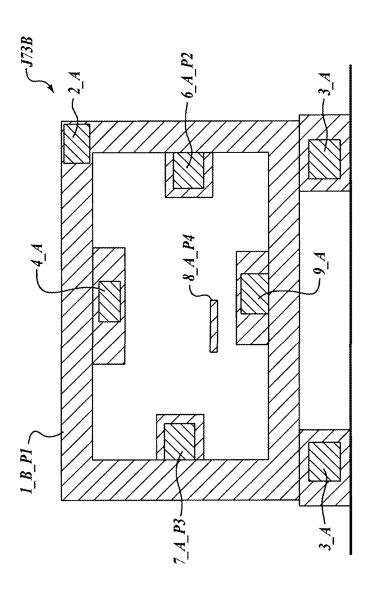


FIG.5

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IP 73456 TO BUILD UP PANEL

ATTACH 73W12-1PANEL TO MAIN ASSY (1_B_P1)
PIN (8_A_P4) RETRIEVE TOOL J73B 202 COP 10

INSTALL STIFFENER LOCATOR (6_A_P2)
INSTALL STIFFENER LOCATOR (7_A_P3) 206 ~ OP 30

DRILL HOLE X, Y, V, Z WITH DRILL FEATURE (9_A) 208 TOP 40 210 ~ OP 50